

Work Order ID 65004

Wednesday, January 05, 2011 1:25:57 PM



Page 1

Item ID: D3220-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 1/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*RL*Date: *11-01-5*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3220

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3220

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

*B11-1-6**(C)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 2

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Required Date: 1/14/2011 Req'd Qty: 4.00

Reference:

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

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Page 3

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Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 1/5/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 180A

0.00



Packaging

Memo

0.00

Packaging

11/01/10 6

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/10
CL 11/01/10

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Picklist Print

Wednesday, January 05, 2011 1:26:01 PM

Page 1

Work Order ID: 65004



Parent Item: D3220-3



Parent Item Name: Doubler

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-06 JLM
 IPP: B 06.11.15 waterjet EC
 IPP C: 08.11.26 Comment added to step 2 KJ Verified by: eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

81.3847

0.5937

2.499789



B11-1-6

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

81.3847

111381

11.89

113189

0.3947

114968

69.1

114968

(6)

W/O:		WORK ORDER CHANGES					
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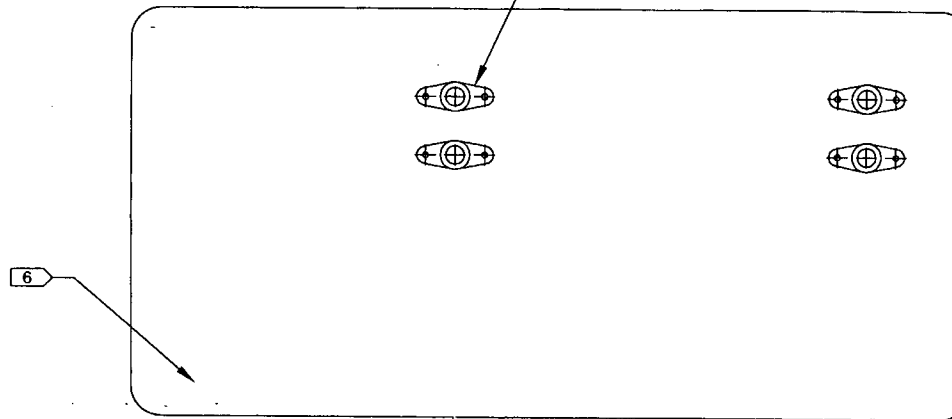
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65004
2811-037

Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET

B
MS21059L4 NUTPLATE
MS20426AD3-3 RIVET, 2X
4 PL



D3220-1/2 DOUBLER

D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025		RF	09.07.08
A	NEW ISSUE		CP	03.10.16
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B D3220 SHEET 1 OF 4 TITLE SCALE DOUBLER NTS DATE 09.07.08 <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	RF			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				

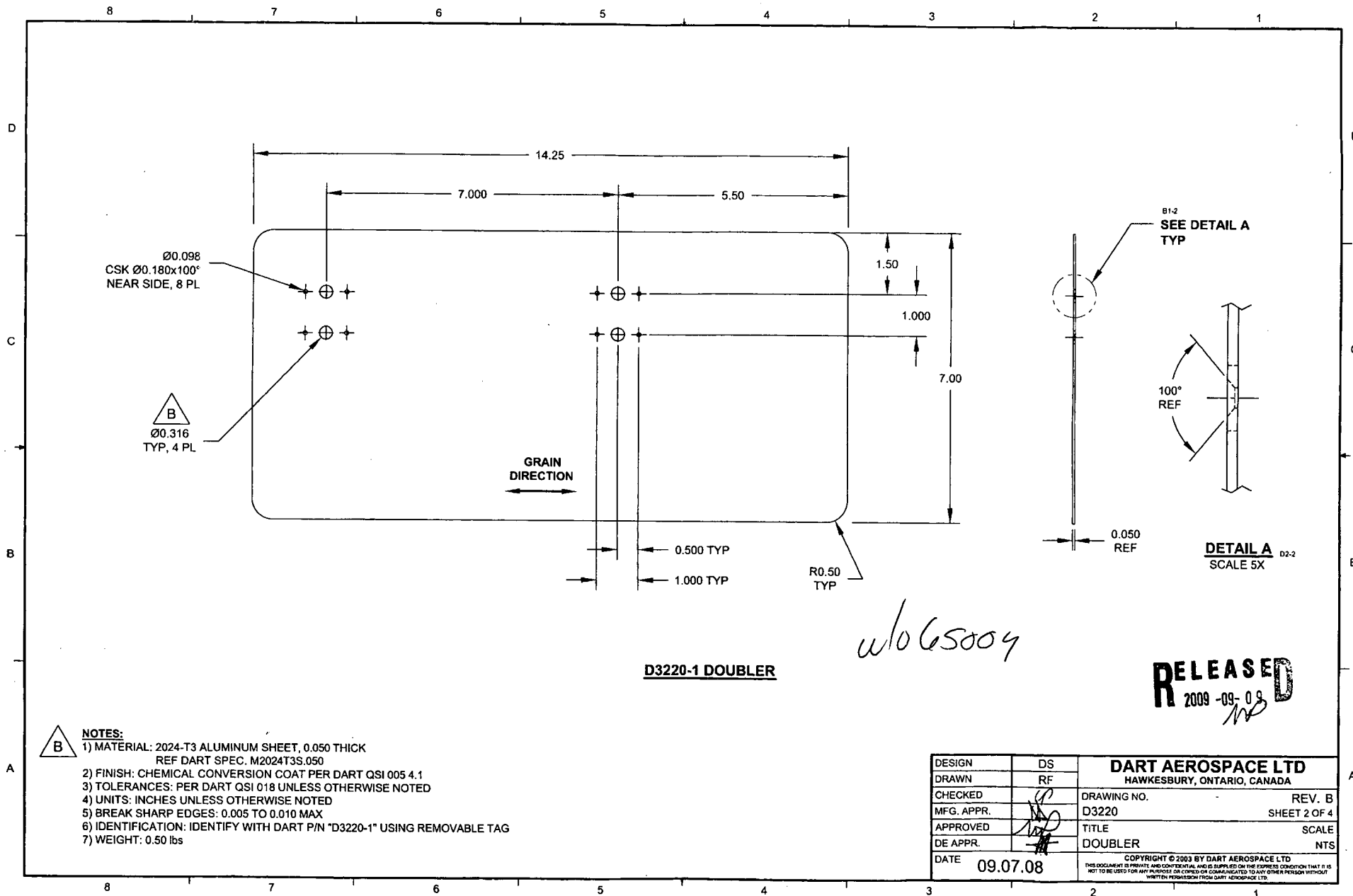
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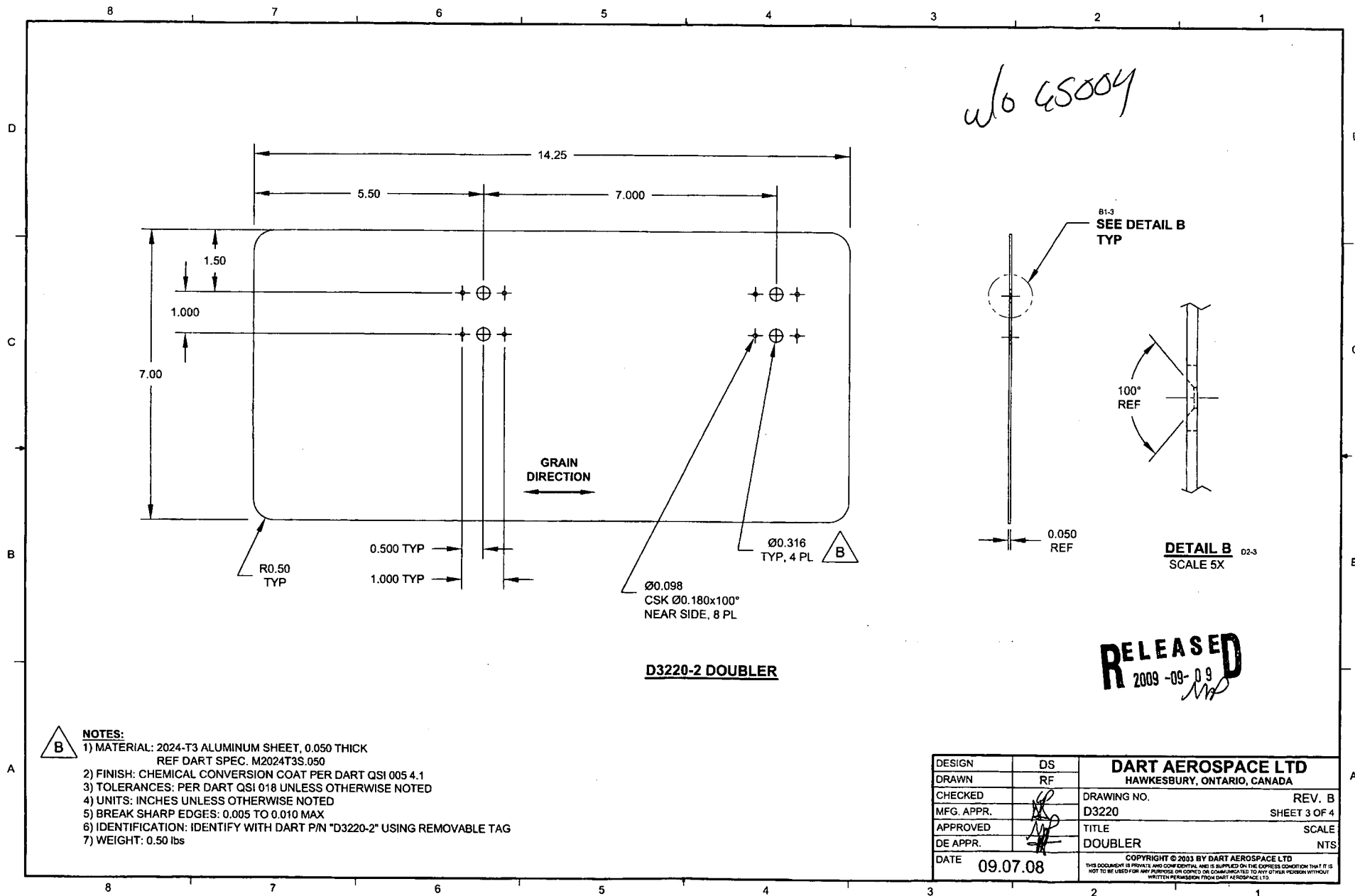
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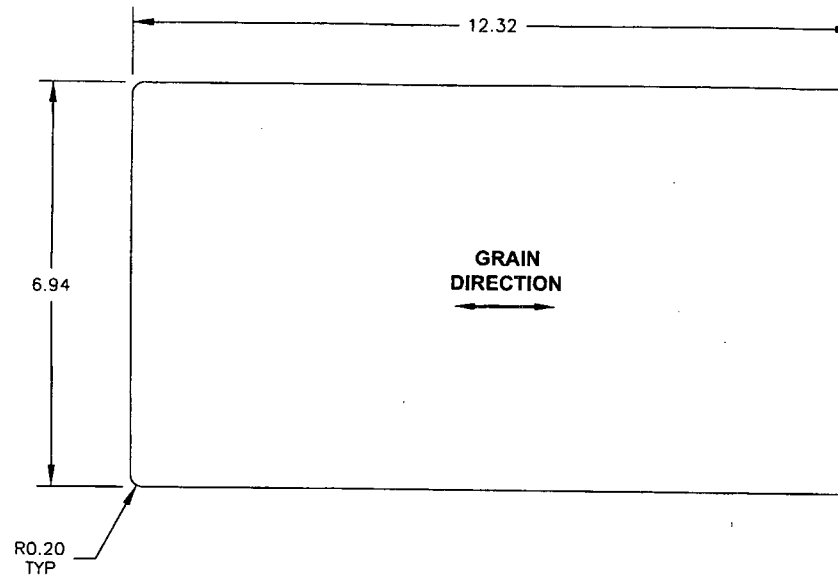
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W/O 65004



D3220-3 DOUBLER

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.43 lbs

DESIGN		DS	DART AEROSPACE LTD	
DRAWN		RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		RF	DRAWING NO.	REV. B
MFG. APPR.			D3220	SHEET 4 OF 4
APPROVED			TITLE	SCALE
DE APPR.			DOUBLER	NTS
DATE	09.07.08		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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